

Work Order ID 52229

October 5, 2009 2:42:24 PM



Page 1

Item ID: D3315-4 **GY**

Accept



Setup Start



Revision ID: B

Stop



Item Name: Wearplate

Start Date: 9/21/09 Start Qty: 4.00



Cust Item ID:

Required Date: 10/02/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: **U**

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3315

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3315
Deburr if necessary

Dwg Rev: **B**

Prog Rev: **B** 2-

B 9-928

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-928

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) S 09/10/05

(XG) 9

Work Order ID 52229

Monday, September 21, 2009 11:41:43 AM



Page 2

Item ID: D3315-4

Accept



Setup Start



Revision ID: B

Stop



Item Name: Wearplate

Start Date: 9/21/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/2/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: B

SB 09/09/23

6

2

140

0.00



QC

QC6- Inspect dimensions to drawing

Memo

0.00

Quality Control

2509/09/08

6

1

150

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld hard surface using D3315-4T3 as per QSI 004 and Dwg D3315 Rev:

☐ Qty Part Number Description Batch ☐ A/R

N/A 7560 Hardcoat Rod M109060

EL 9-10-1 6

Work Order ID 52229

Monday, September 21, 2009 11:41:43 AM

Page 4

Item ID: D3315-4

Accept

Revision ID: B

Item Name: Wearplate

Start Date: 9/21/2009 Start Qty: 4.00

Required Date: 10/2/2009 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

SAD 09-10-06

(4)

Quality Control

200

Packaging

0.00



Packaging

Memo

0.00

Identify on inside surface using a permanent fine point marker with the following: □TCCA-PDA, Dart Aerospace Ltd. □P/N: D3315-4, B/N: BXXXXX □For Product Eligibility see PDA04-17 □and Stock □Location: 31496

SAD 09-10-06

(4)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/07 *
u 09-10-07

Picklist Print

Page 1

Monday, September 21, 2009 11:41:43 AM

Work Order ID: 52229



Parent Item: D3315-4RevB



Parent Item Name: Wearplate



Start Date: 9/21/2009

Required Date: 10/2/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010S16GA  1010/1025 sheet 16GA		Purchased	No			100	sf	111.6200	9.6674	14.50		
											189-4-28	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111.62

105706 - ?

0.6

111410

111.02

105 706 X 5
111410 X 1

DART

SHIP NAME

RETURN TO

ENGINEERING

UNCONTROLLED COPY

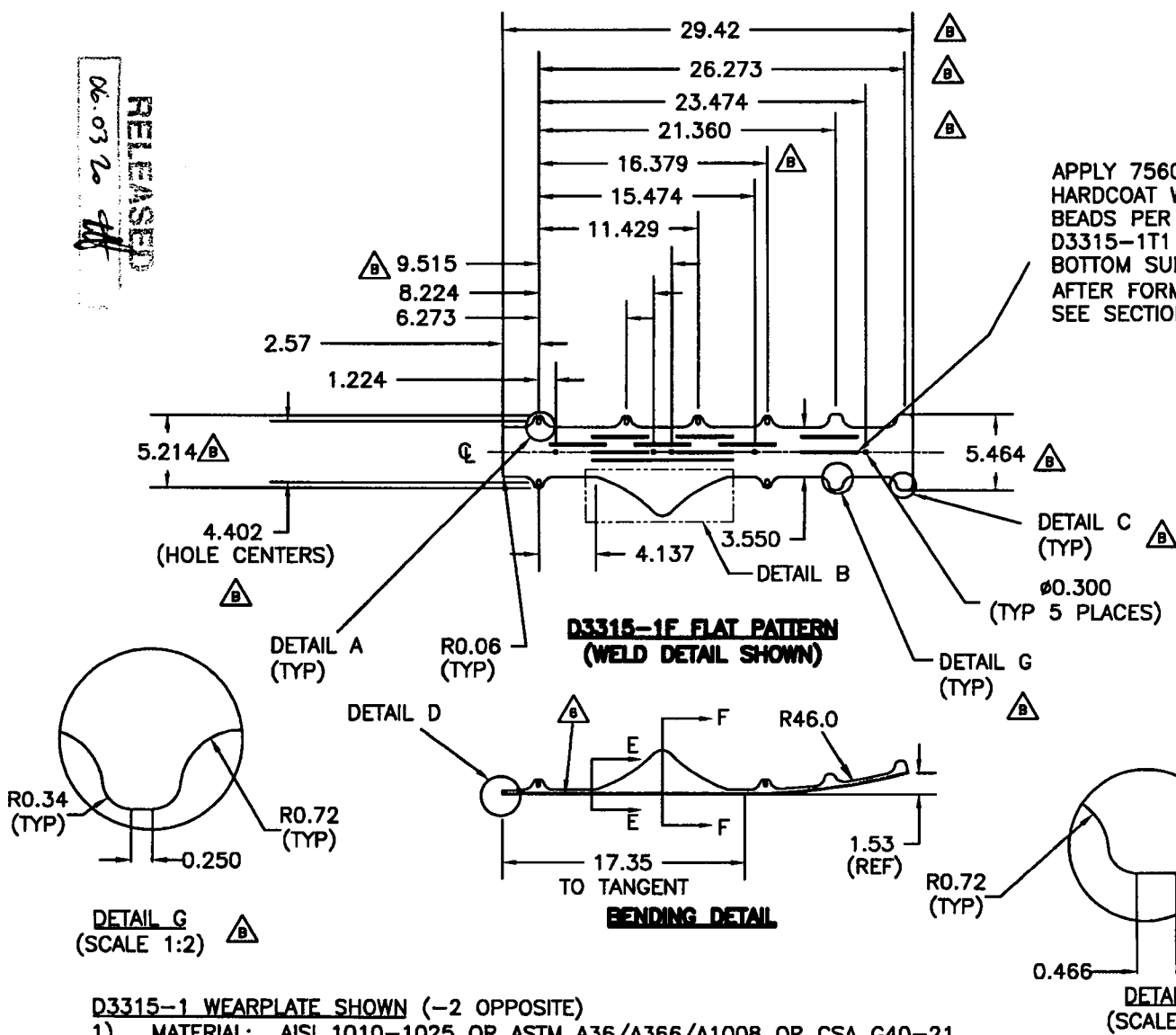
SUBJECT TO AMENDMENT

WITHOUT NOTICE



WORK ORDER

NO. 52229

APPLY 7560
HARDCOAT WELD
BEADS PER
D3315-1T1 ON
BOTTOM SURFACE
AFTER FORMING (TYP),
SEE SECTION E-E

**D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
04		04		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3315	SHEET 1 OF 4	
DATE	TITLE		SCALE	
06.01.31	WEARPLATE		1:12	
A	04.09.10	NEW ISSUE		
B	06.01.31	UPDATE DIMENSIONS		

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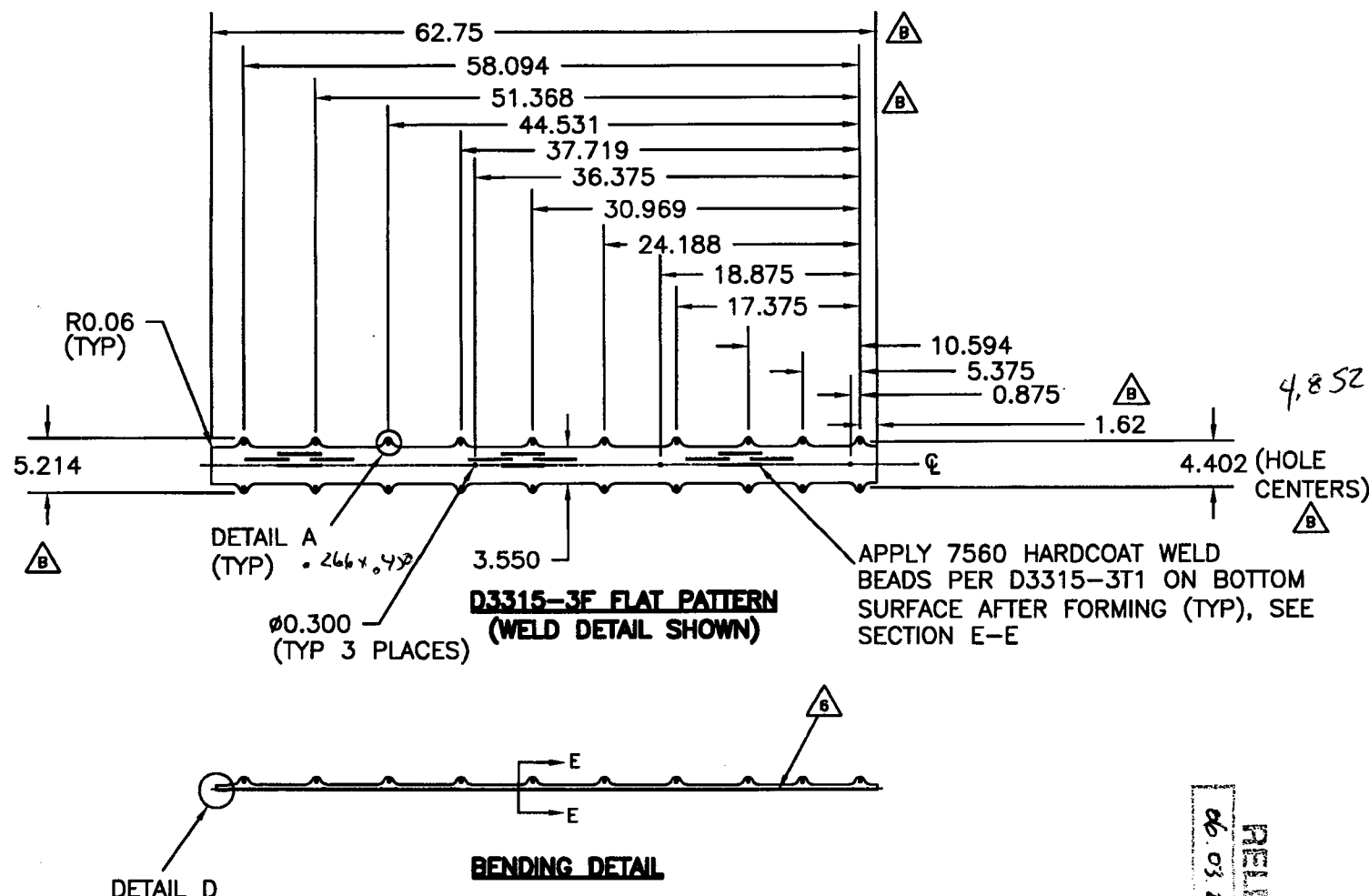
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RELEASED

06.03.20

DART

W/O 52229



D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

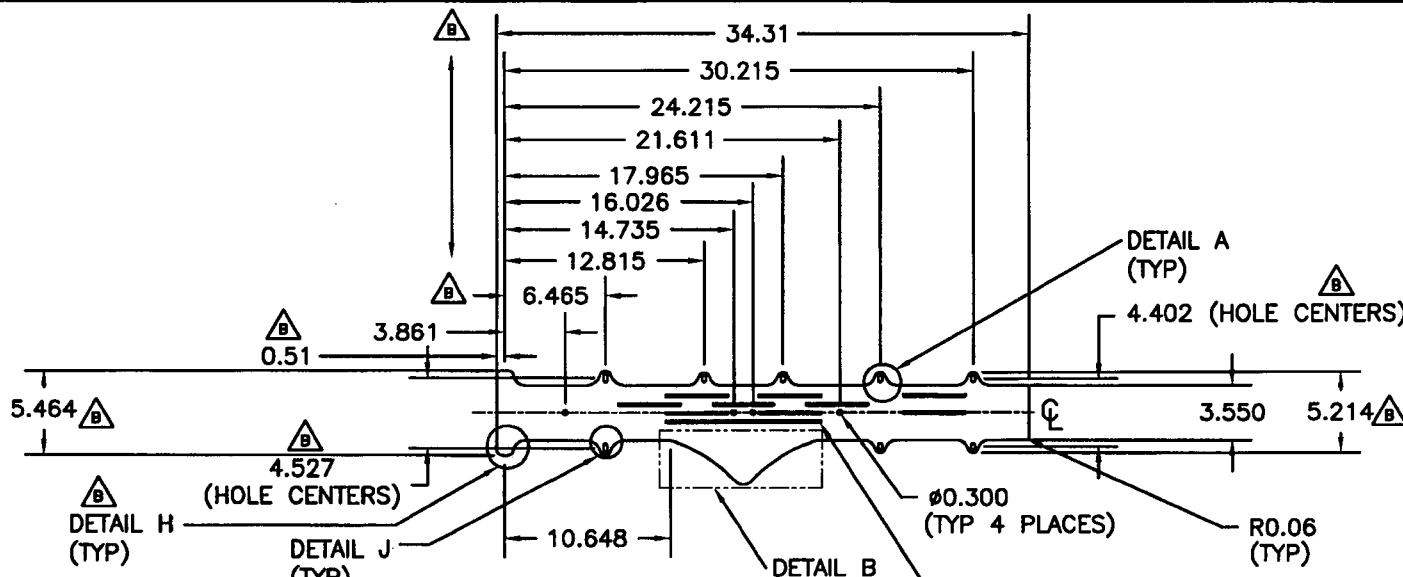
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06 03 20

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DATE	06.01.31	TITLE	D3315	SHEET 2 OF 4
		WEARPLATE		SCALE 1:18

DART

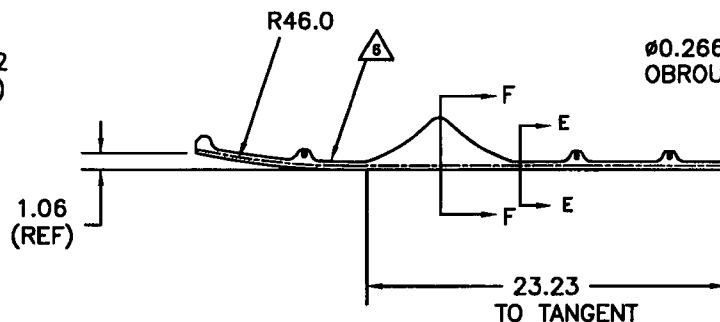
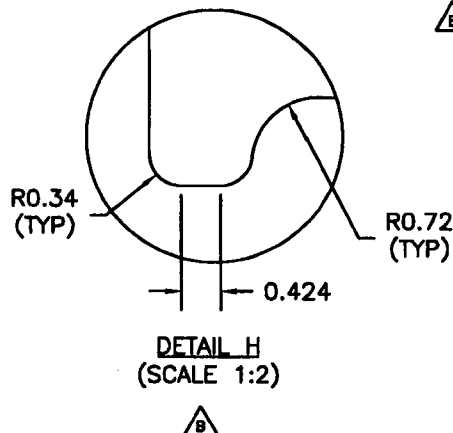
W/O 52229

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TITLE	WEARPLATE	SCALE	1:12	

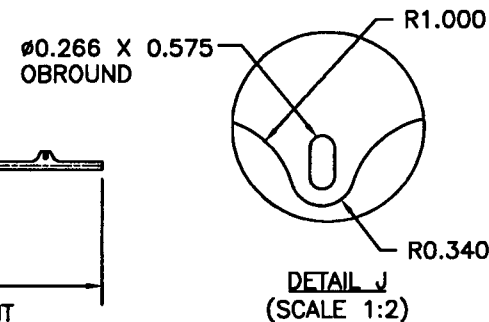


**D3315-5F FLAT PATTERN
(WELD DETAIL SHOWN)**

APPLY 7560 HARDCOAT WELD
BEADS PER D3315-5T1 ON BOTTOM SURFACE
AFTER FORMING (TYP), SEE SECTION E-E



BENDING DETAIL



D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

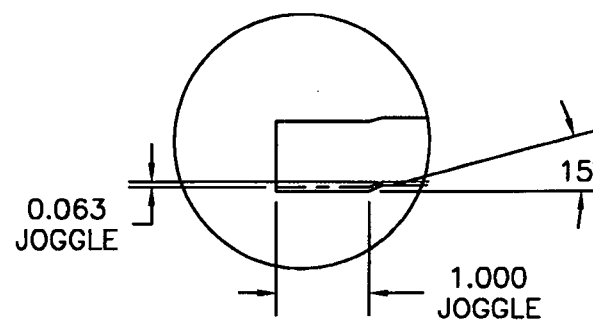
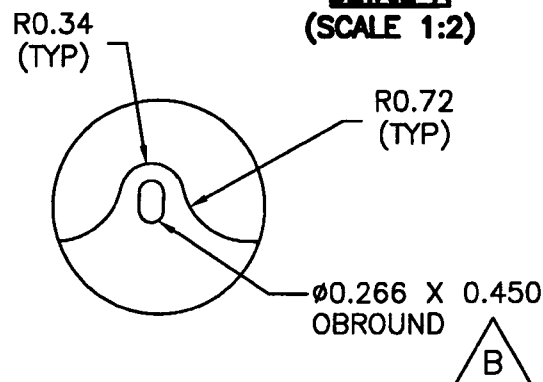
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- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"



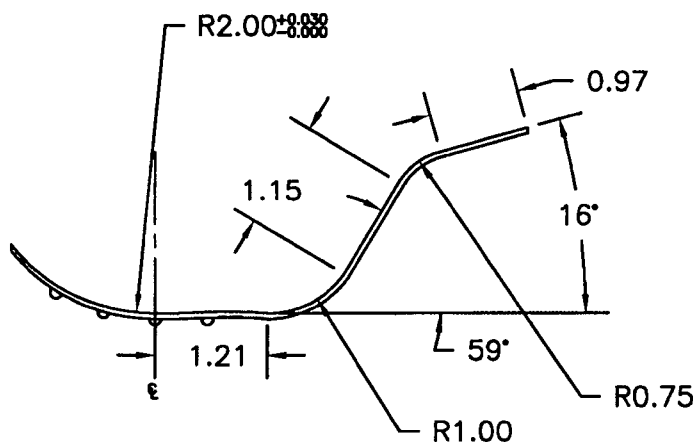
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CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	TITLE	WEARPLATE	REV. B
		DRAWING NO.	D3315	SHEET 4 OF 4
				SCALE
				NIS

DETAIL A
(SCALE 1:2)



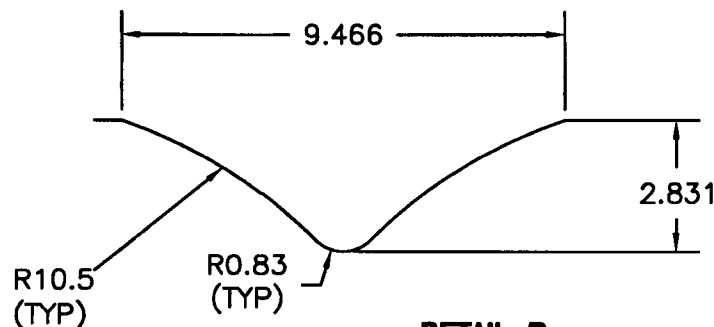
DETAIL D
(SCALE 1:2)



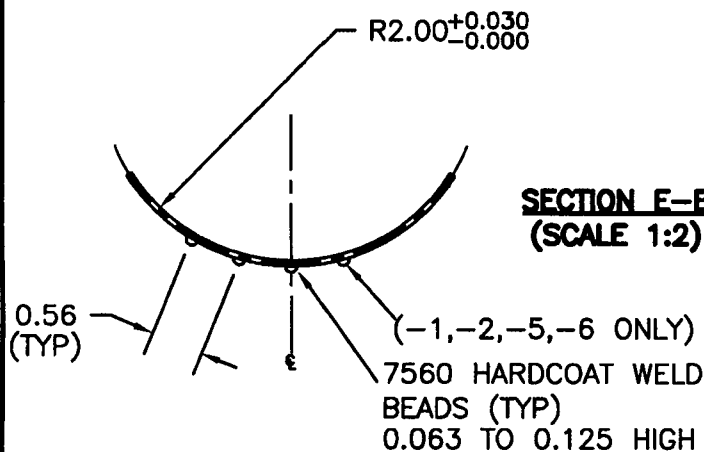
SECTION F-F
(SCALE 1:2)



DETAIL B
(SCALE 1:4)



SECTION E-E
(SCALE 1:2)



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06.03.20

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